

Work Order ID 75039

75039

Page 1

October-17-11 10:31:01 AM

Item ID: D3536-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Gasket
 Start Date: 17/10/2011 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 27/10/2011 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
 Deburr if necessary

11-10-18

(26)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

11-10-18

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

8 units

count
(26)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11/10/19 JP 20

11/10/20 ME
 11-10-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-17-11 10:31:05 AM

Page 1

Work Order ID: 75039

75039

Parent Item: D3536-25

D3536-25

Parent Item Name: Gasket

Start Date: 17/10/2011

Required Date: 27/10/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MNEO60S.063

Purchased

No

100

sf

473.8500

0.5956

10.58844

15.5

MNEO60S 063

**

10-11-18

NEOPRENE SHEET 0.063

Location

Loc Qty

Loc Code

MAT052

473.85

117295

55.68

118026

127.87

118663

4.3

119130

286

119130

26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75039
Description: Gasket		Part Number:	D3536-25
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
21.80	+/-0.030	21.80	✓		T B1	
16.35	+/-0.030	16.35	✓		T	
10.90	+/-0.030	10.90	✓		T	
5.45	+/-0.030	5.45	✓		T	
6.00	+/-0.030	6.00	✓		T	
6.75	+/-0.030	6.75	✓		T	
12.75	+/-0.030	12.75	✓		T	
1.89	+/-0.030	1.894	✓		V B2	
0.30	+/-0.030	.306	✓		V	
0.30	+/-0.030	.308	✓		V	
Ø0.19	+0.005/-0.001	.190	✓		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	11-10-18	Date:	11/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	E

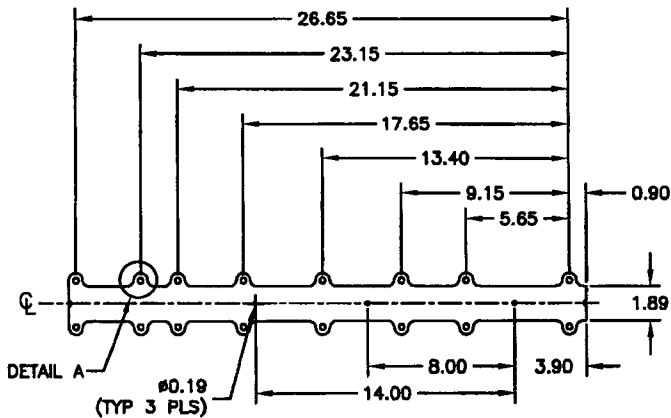
DART

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CHECKED	PH	APPROVED	PH	DRAWING NO.	PORT HADLOCK, WA
DATE	06.10.25			D3536	SHEET 1 OF 6
				TITLE	SCALE
				GASKET	1:10
A		06.10.25		NEW ISSUE	

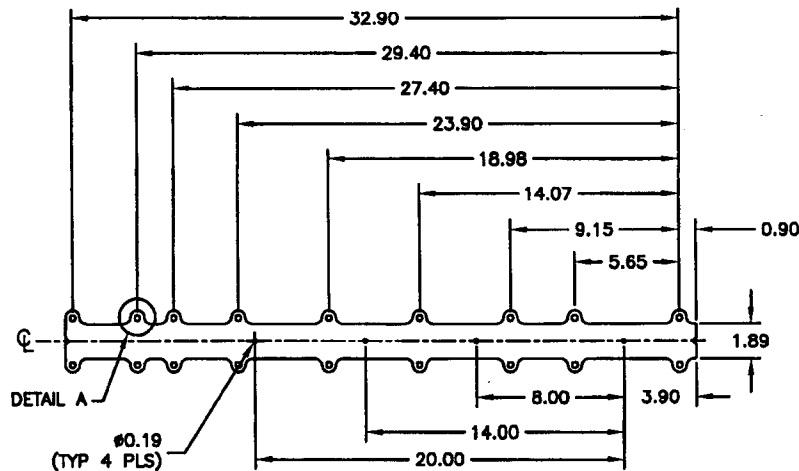
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75039

11-10-17



D3536-11 GASKET



D3536-13 GASKET

NOTES

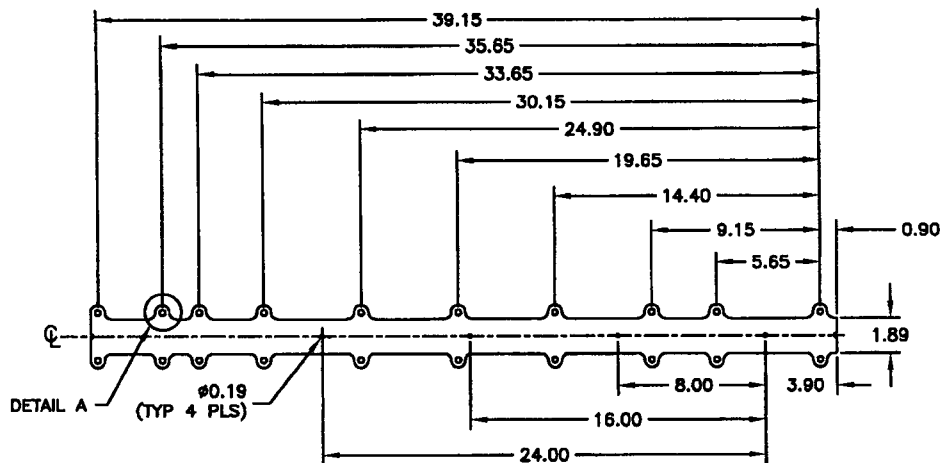
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



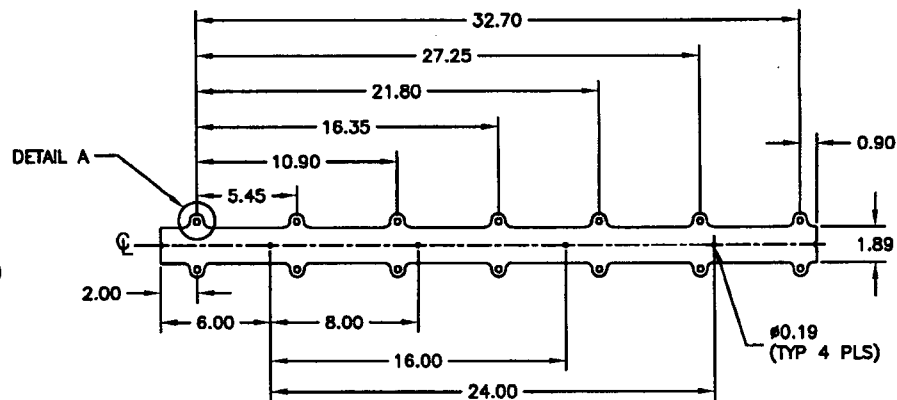
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		TITLE	GASKET	SHEET 2 OF 6
				SCALE 1:10

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07.02.12

75039



D3536-15 GASKET



D3536-21 GASKET

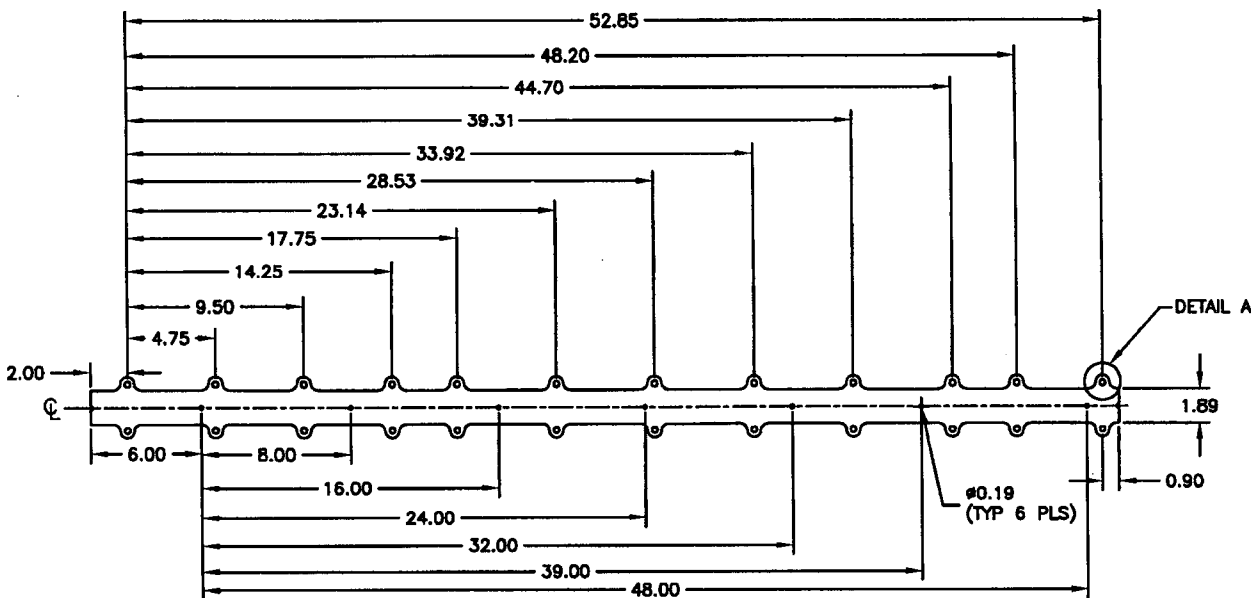
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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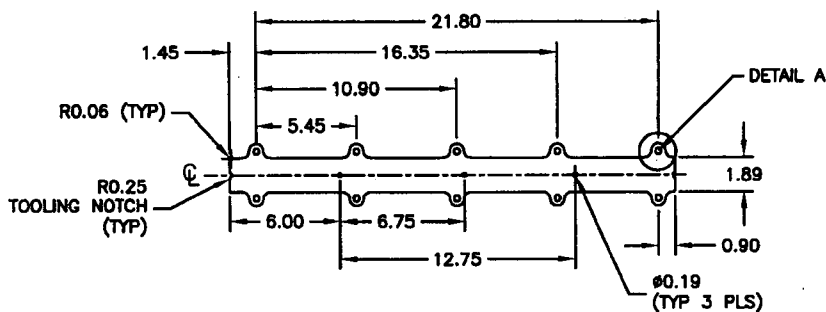
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 3 OF 6
		SCALE	1:10	

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D3536-23 GASKET

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D3536-25 GASKET

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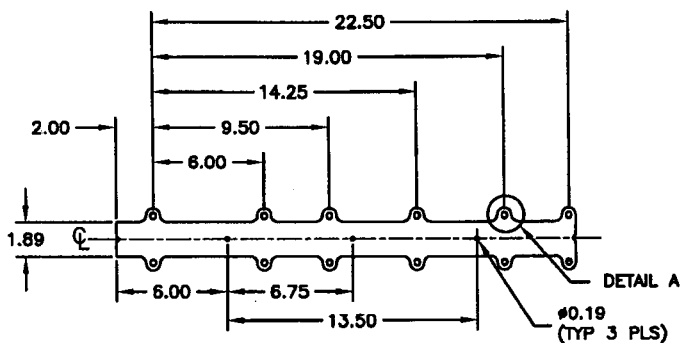
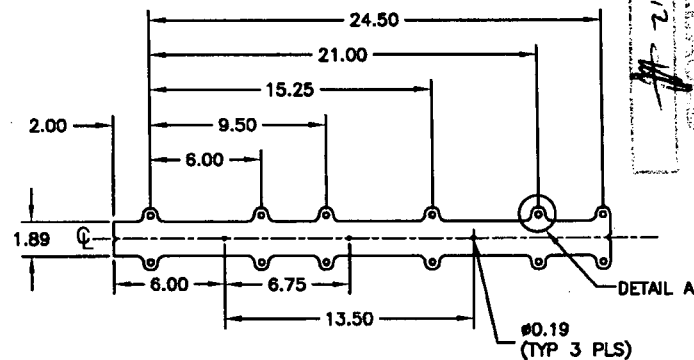
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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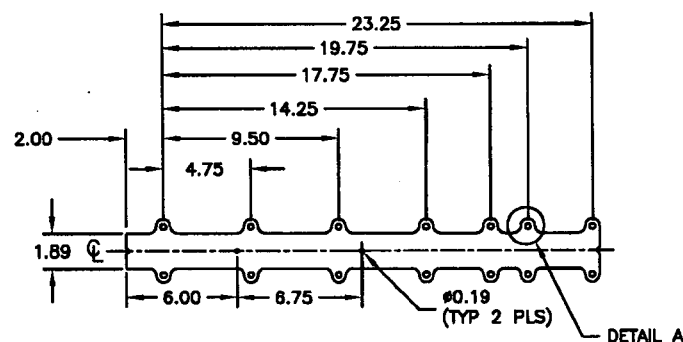
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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE 1:10

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07.02.12

**D3536-31 GASKET****D3536-33 GASKET**

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**D3536-35 GASKET****NOTES**

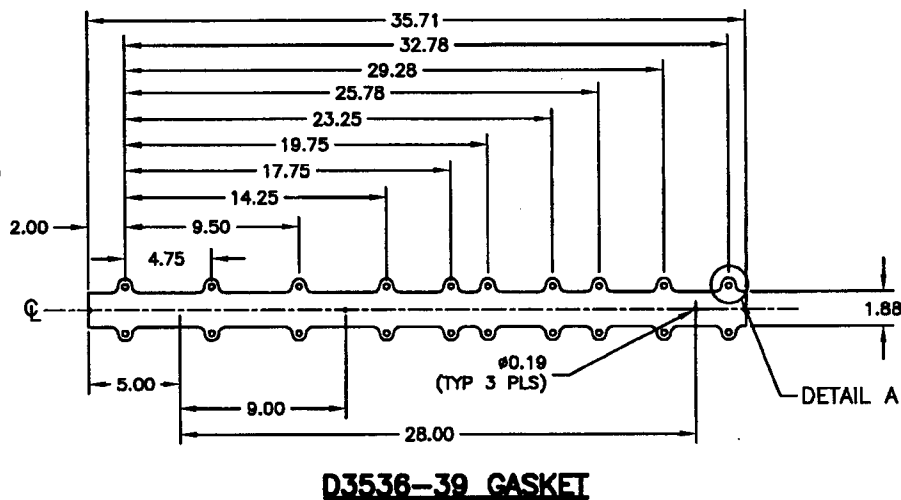
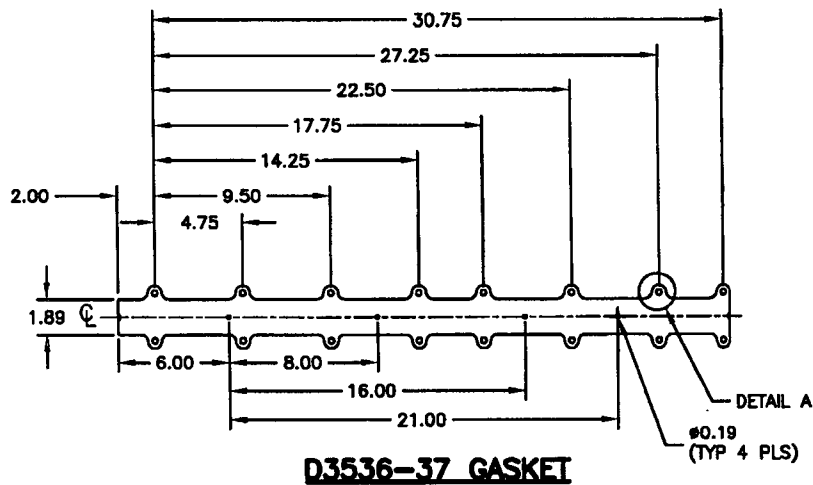
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- 2) FINISH: NONE
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DATE	06.10.25	TITLE	D3536	REV. A
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				SCALE 1:10

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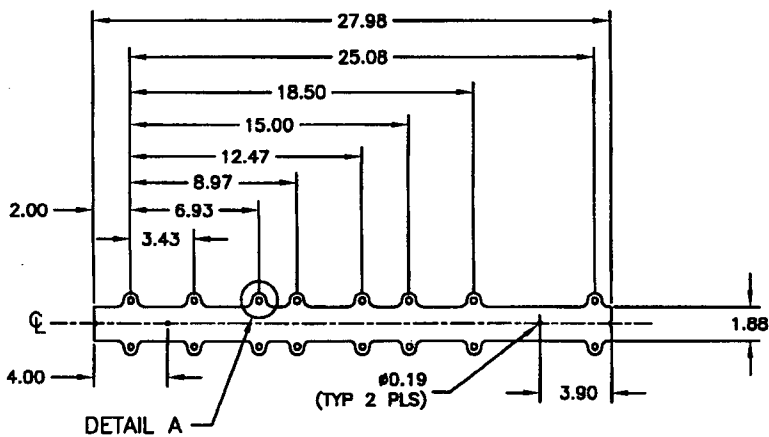
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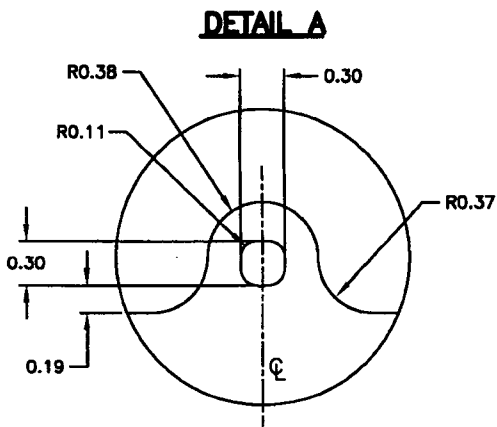
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CHECKED	PH	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	06.10.25	DRAWING NO.	D3536	REV. A	
		TITLE	GASKET	SHEET 6 OF 6	
		SCALE		1:10	

07-02-12 *AK*

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D3536-41 GASKET



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